



Dart Aerospace Ltd.
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Hawkesbury, ON
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Tel (613) 632-5200

D3915-041
Job Sheet 176465



Part No: D3915-041

Job Qty: 1 ea

Part Name: Light Lid Assembly, Long Basket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/24/18

Job Tracking No:

Due Date: 5/21/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV F SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C add realodine DD 10.04.26 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 13.07.08 as per dwg rev.D DD verf:JLM IPP REV:D 13.08.21 DWG REV.E / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	5/21/18	5/21/18	0.00	0.00	Start Up Large Fab-5		DC 2018-06-20
100	Large Fab	1 pcs	5/21/18	5/21/18	0.00	3.33	Large Fab 2		CC 18.6.20
110	QC	1 pcs	5/21/18	5/21/18	0.00	0.00	QC9		18-06-20
120	QC	1 pcs	5/21/18	5/21/18	0.00	0.00	QC5		18-06-20
130	HandFinish	1 pcs	5/21/18	5/21/18	0.00	1.00	HandFinish1		BEB 18-06-25
140	Large Fab	1 pcs	5/21/18	5/21/18	0.00	3.33	Large Fab 2		CC 18.6.20
150	QC	1 pcs	5/21/18	5/21/18	0.00	0.00	QC9		14 2018-06-21
155	QC	1 pcs	5/21/18	5/21/18	0.00	0.00	QC5		14 2018-06-21
157	HandFinish	1 pcs	5/21/18	5/21/18	0.00	1.00	HandFinish1		BEB 18-06-27
160	Powdercoat	1 pcs	5/21/18	5/21/18	0.00	0.83	Powdercoat1		BP 18-7-13
170	QC	1 pcs	5/21/18	5/21/18	0.00	0.00	QC3		18-06-25
180	HandFinish	1 pcs	5/21/18	5/21/18	0.00	0.81	HandFinish4		18-08-28
190	QC	1 pcs	5/21/18	5/21/18	0.00	0.00	QC5		18-08-28
200	Packaging	1 pcs	5/21/18	5/21/18	0.00	0.00	Packaging3-2		21
210	QC21-SA	1 Ea	5/21/18	5/21/18	0.00	0.00	QC21		9-89 AUG 28 2018

Part Op 100 - 1- assemble ribs , weld as per dwg D3915 using DT9606A. When welding D4019-3, weld top and bottom then make Descriptions: a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with weld. ****DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME**** 2- weld hinge, label plate and Mounting plates as per dwg D3915

120 - -Scribe Dart P/N and B/N as per dwg. Using 0.13 (minimum) high lettering per QSI 044 6.4

130 - ***ENSURE TO RINSE CAREFULLY ACID AND ALODINE***

140 - 1- weld (4) corners

155 - ***inspect fit of lid with base***

157 - 1- realodine corners ***do not acid etch***

160 - 1- touch up corner with alodine only 2- Plug holes prior to finish 3-Mask this area prior to finish View B-B 1ST COAT:

START TIME: 0440 OVEN TEMPERATURE: 300 FINISH TIME: 11:10 ***** 2nd

coat if necessary ***** 2ND COAT: START TIME: OVEN TEMPERATURE:

FINISH TIME:

180 - 1- Install webbing as per dwg 2- Install placard and label as per dwg

2C 1018-00-30

1018-00-30
1018-00-30

23
28E

23
28E

005281

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2957	Mounting Plate	4 Ea (4 ea)	90-Start up Operation	5072591
D3915-1	Rib	2 Ea (2 ea)	90-Start up Operation	5072591
D4016-5	Hinge Half, Light Lid	3 Ea (3 ea)	90-Start up Operation	5072591
D4019-3	Rib	3 Ea (3 ea)	90-Start up Operation	5072591
D4035-047	Lid Rib Assembly, Aft (Light)	2 Ea (2 ea)	90-Start up Operation	5072591
D4056-1	Label Plate	1 Ea (1 ea)	90-Start up Operation	5072591
D2728-1	Dart Logo Label Small	1 Ea (1 ea)	180-HandFinish	5072591
D4029-041	Webbing (Long Basket)	1 Ea (1 ea)	180-HandFinish	5072591
MS20600-AD4W4	Rivet	34 Ea (34 ea)	180-HandFinish	5072591
NAS1149DN949J	Washer	34 Ea (34 ea)	180-HandFinish	5072591

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2957	4	0	0
	D3915-1	2	2	0
	D4016-5	3	43	0
	D4019-3	3	3	0
	D4035-047	2	0	0
	D4056-1	1	3	0
180-HandFinish	D2728-1	1	0	0
	D4029-041	1	0	0
	MS20600-AD4W4	34	1,251	0
	NAS1149DN949J	34	224	0

Part Specifications

Specifications could not be found.

Plex 4/24/18 3:28 PM Dart.Gagnon.Michelle

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Container No: S082587



Part: D3915-041

Job No: 176465

Serial No/Batch: S082587

Revision: F

Inspector:

Exp Date:

Instructions:

Date: 06/20/18